

Work Order ID 79203

January-23-12 1:59:12 PM

79203

Page 1

Item ID: D2661-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH Fwd Aft Out 206
 Start Date: 23/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2661	Rev E

100	*100*	HAAS CNC VERTICAL MACHINING #1	0.00	<u>10</u>	<u>0</u>				
HAAS I		Memo	0.00						
HAAS CNC vertical machine #1		Program part number and batch number MACHINE AS PER DWG AND FOLIO FB071 FOLIO REV: <u>AA</u> DWG REV: <u>E</u>							

110	*110*	CONVENTIONAL MILLING MACHINE	0.00	<u>10</u>	<u>0</u>				
Mill Conv		Memo	0.00						
Conventional Milling Machine		Machine Keyway and inspect per attached dimension sheet							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 9h45 FINISH TIME: 9h15	0.00 0.00				10	2	28	12/03/12
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							10X1M-12/03/12
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: 424 Memo	0.00 0.00							12/3/12 JF SD

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/3/12

12-03-12

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Picklist Print

January-23-12 1:59:16 PM

Page 1

Work Order ID: 79203

79203

Parent Item: D2661-2

D2661-2

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	80.0000	1	10			

D6101-003

**

Saddle Billet, 7075

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	86	
73775	2	
73780	7	
77562	10	
78599	60	
MAT042	-7	
MAT044	1	
73769	1	
78159		
79587		

7
3

F.K. 12/02/28

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DART AEROSPACE LTD				Work Order: 79203	
Description: 206 Saddle, Outboard, Right side				Part Number: D2661-2	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.613
B	0.256	0.263		.260	.260	.260	0.256	0.256
C	0.315	0.322		.316	.316	.316	0.315	0.315
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.680
F	1.357	1.367		1.362	1.362	1.362	1.362	1.363
G	0.100	0.140		.120	.120	.121	0.122	0.121
H	0.210	0.230		.226	.226	.227	0.227	0.225
I	0.615	0.685		.680	.680	.680	0.685	0.685
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.325	1.325	1.325	1.325	1.325
L	0.178	0.198		.188	.188	.188	0.188	0.188
M	0.470	0.530		.500	.500	.500	0.500	0.500
N	1.125	1.145		1.1365	1.1365	1.137	1.137	1.136
O	0.100	0.180		.135	.135	1.35	0.140	0.140
P	0.100	0.140		.129	.127	.127	0.131	0.131
Q	0.240	0.260		.250	.250	.251	0.250	0.252
R	0.677	0.697		.687	.687	.687	0.689	0.690
S	0.100	0.140		.120	.121	.121	0.125	0.126
T	1.565	1.585		1.5765	1.576	1.5765	1.577	1.569
U	0.540	0.560		.550	.551	.550	0.547	0.548
V	0.912	0.932		.921	.921	.921	0.923	0.923
W	0.787	0.807		.797	.797	.797	0.798	0.798
X	5.990	6.010		6.000	6.000	6.000	6.002	6.001
Y	4.995	5.005		5.000	5.000	5.000	5.001	5.000
Z	0.490	0.510		.498	.498	.498	0.501	0.502
AA	0.312	0.319		.314	.314	.314	0.313	0.313
AB	0.990	1.010		1.000	1.000	1.000	1.001	1.001
AC	1.245	1.255		1.250	1.250	1.250	1.253	1.254
AD	0.490	0.510		.500	.500	.500	0.502	0.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.752
AF	0.235	0.240		.236	.236	.236	0.237	0.237
AG	0.510	0.515		.512	.512	.512	0.512	0.513
AH	0.100	0.120		.109	.109	.109	0.112	0.110
AI								

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Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: PD/BA	Date: 12/03/01
Audited by: RE	Date: 12.3.1
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

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FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6 X	7 X	8 X	9 X	10 X
A	3.611	3.621		3.614	3.613	3.612	3.613	3.612
B	0.256	0.263		0.256	0.256	0.256	0.256	0.256
C	0.315	0.322		0.315	0.315	0.315	0.315	0.315
D	2.495	2.505		2.500	2.500	2.500	2.500	2.498
E	1.674	1.684		1.680	1.677	1.678	1.677	1.679
F	1.357	1.367		1.362	1.361	1.361	1.361	1.361
G	0.100	0.140		0.121	0.121	0.122	0.121	0.122
H	0.210	0.230		0.225	0.224	0.225	0.224	0.226
I	0.615	0.685		0.685	0.685	0.685	0.685	0.685
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.325	1.325	1.325	1.325	1.325
L	0.178	0.198		0.188	0.188	0.188	0.188	0.188
M	0.470	0.530		0.500	0.500	0.500	0.500	0.500
N	1.125	1.145		1.138	1.138	1.138	1.138	1.138
O	0.100	0.180		0.140	0.140	0.140	0.140	0.140
P	0.100	0.140		0.131	0.131	0.131	0.130	0.130
Q	0.240	0.260		0.250	0.250	0.250	0.250	0.250
R	0.677	0.697		0.686	0.689	0.687	0.688	0.687
S	0.100	0.140		0.128	0.125	0.127	0.125	0.126
T	1.565	1.585		1.568	1.569	1.569	1.570	1.569
U	0.540	0.560		0.553	0.550	0.549	0.549	0.548
V	0.912	0.932		0.924	0.923	0.923	0.921	0.923
W	0.787	0.807		0.797	0.798	0.798	0.796	0.798
X	5.990	6.010		6.001	6.002	6.002	6.001	6.000
Y	4.995	5.005		5.002	4.998	4.999	4.998	4.998
Z	0.490	0.510		0.507	0.502	0.502	0.499	0.502
AA	0.312	0.319		0.313	0.313	0.313	0.313	0.313
AB	0.990	1.010		1.001	1.002	1.000	1.000	1.000
AC	1.245	1.255		1.249	1.250	1.248	1.250	1.249
AD	0.490	0.510		0.502	0.502	0.503	0.502	0.501
AE	3.745	3.755		3.751	3.750	3.750	3.748	3.751
AF	0.235	0.240		0.237	0.237	0.236	0.237	0.237
AG	0.510	0.515		0.512	0.512	0.513	0.513	0.513
AH	0.100	0.120		0.110	0.110	0.110	0.111	0.110
AI								

DART AEROSPACE LTD		Work Order:	79203
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

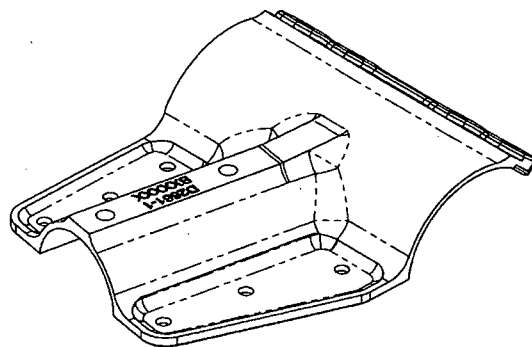
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: PD/B.A	Date: 12/03/01
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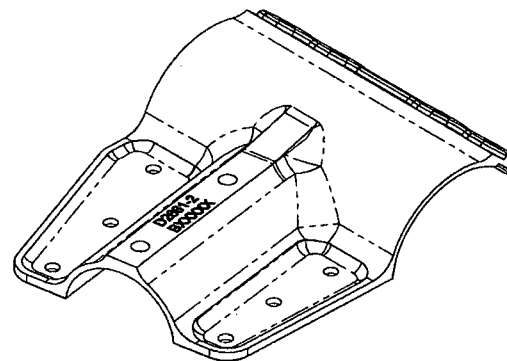
Audited by: [Signature]	Date: 2-3-1
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Prototype Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	[Signature]



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

RELEASED
R 2011-11-16

UNCONTROLLED
SUBJECT TO A
WITH A
WORK
NO. 79203 M.L.J
12/01/23

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.31		

DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D2661	REV. E SHEET 1 OF 5
TITLE SADDLE, OUTSIDE	SCALE NTS
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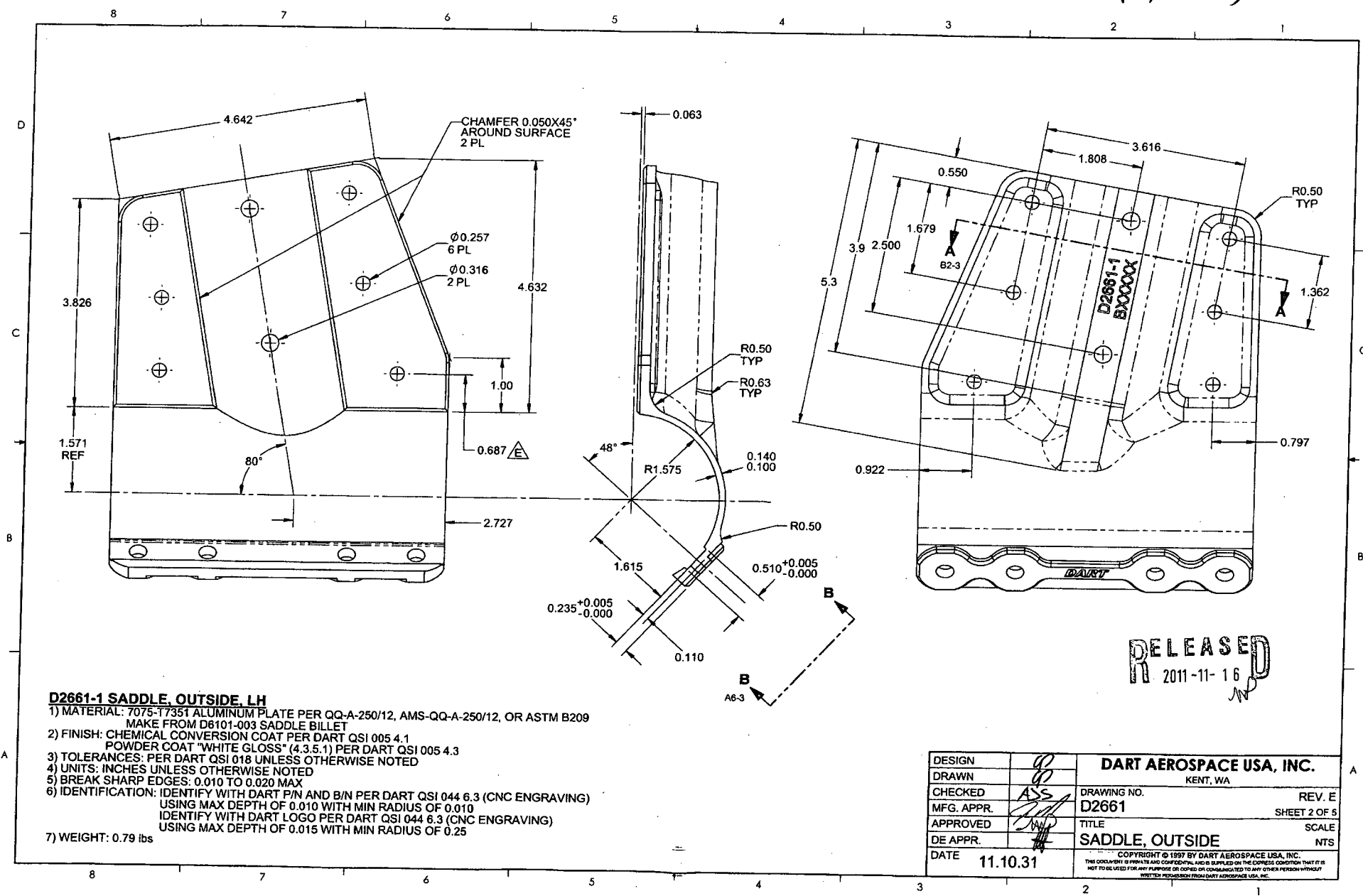
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79203



RELEASED
2011-11-16

D2661-1 SADDLE, OUTSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN	g	DART AEROSPACE USA, INC.	
DRAWN	g	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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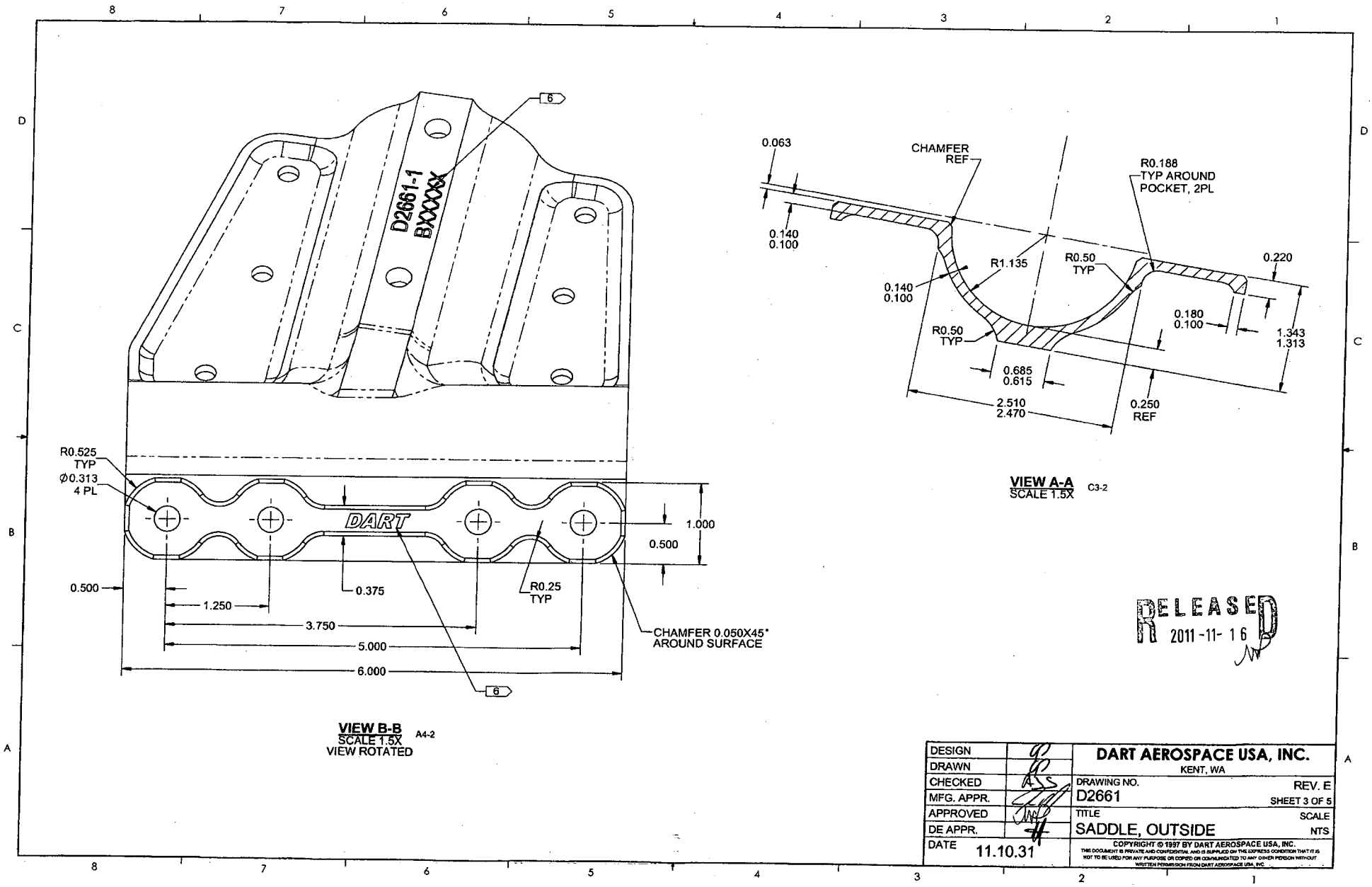
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RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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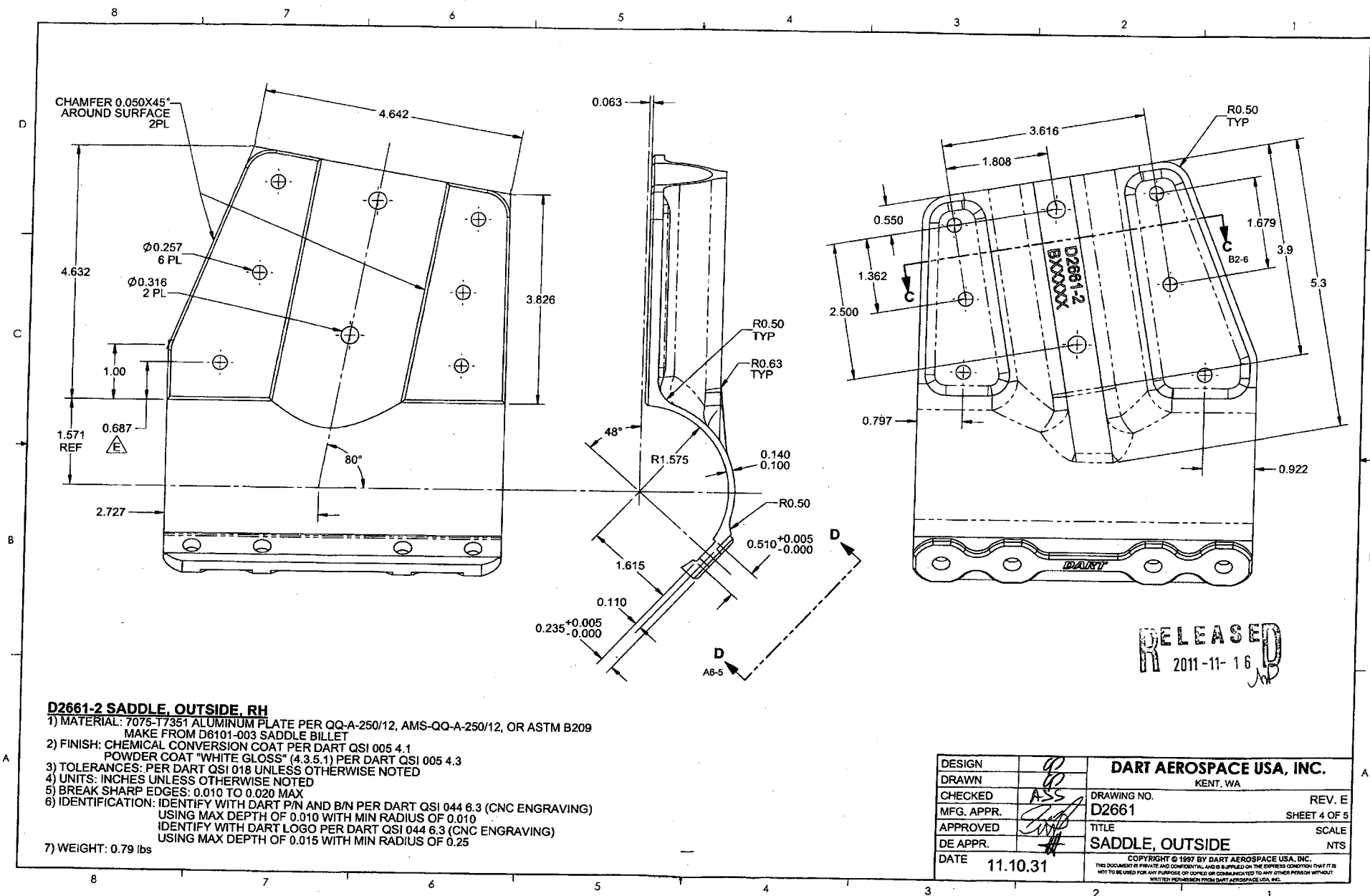
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

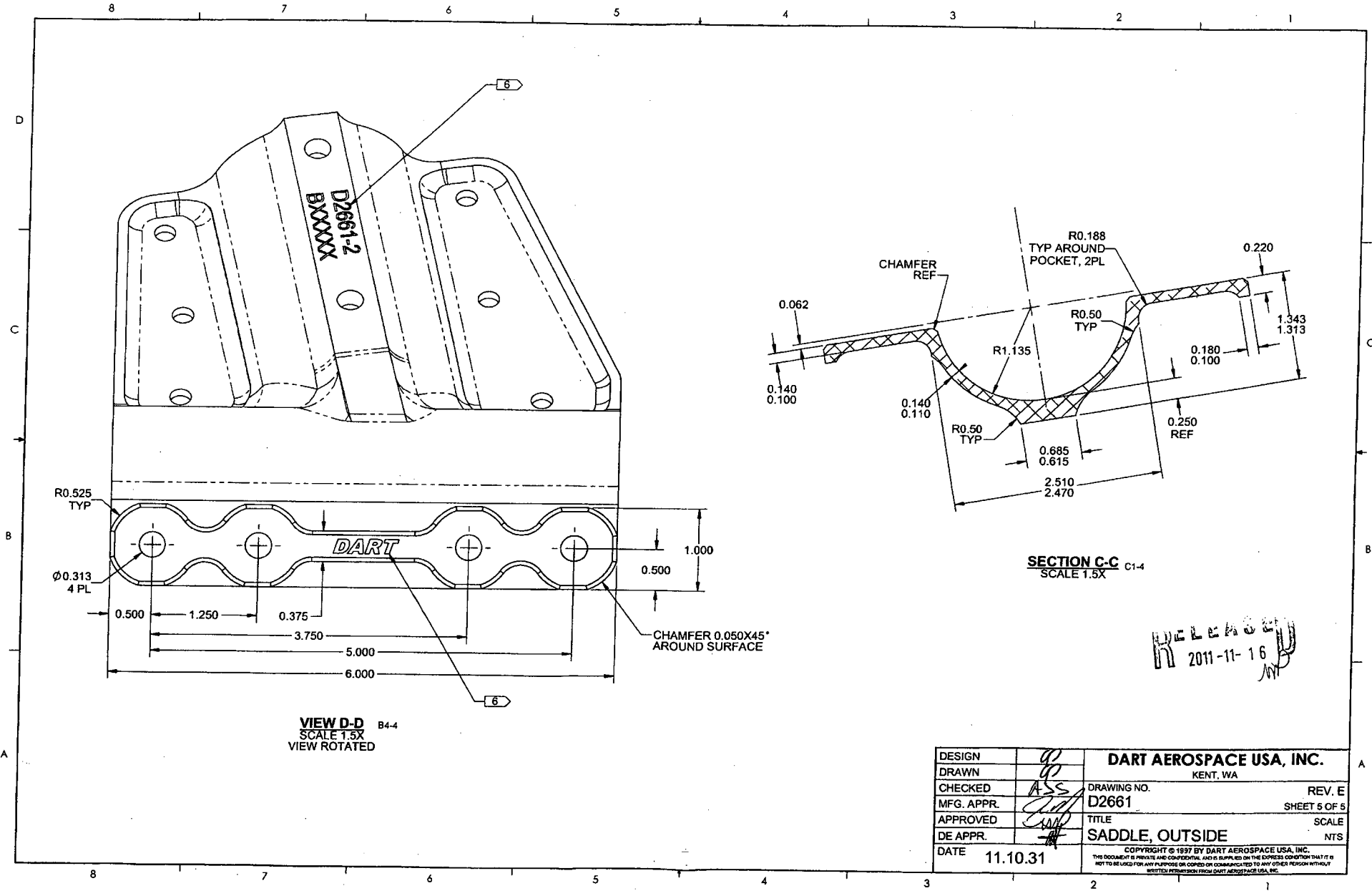
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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